

RG 104, 8NS-104-94-077
Box 6

8NS-104-94-077, Miscellaneous
Correspondence & Memos, 1897-1994

Notes on Philippine Currency

Government PHILIPPINE

No. Pieces 80,000,000

Date order received March-1971
Mint where coined Denver
Denomination 10 Sentimo
Date coinage started 3/17/71
Date coinage completed August 4, 1971
Cost per M _____
Alloy German Silver 70% Copper
18% Zinc, 12% Nickel
Weight per coin 30.87⁺ 2 Grain
Weight tolerance + 2 Grains
Fineness _____ Tol. _____
Diameter .705 Tol. + 3
Thickness .048 Tol. _____
Reeded edge Yes
Plain edge -
Lettered edge -
Wastage allowed per M _____
Turn - standard or medal Standard
Year (dated) 1971
Mint mark _____
Was sample coin submitted Yes-
Was sample strike approved _____
Die average:
Obv. - 300,000
Rev. - 266,000
Remarks:
Dime (U.S.) equipment used in stamping and upsetting.

Was master die furnished _____
Was master die returned _____
Number melts made 1577
No, melts delivered to Coiner 1577
Ounces per melt 5800
No. ingots per melt 1
Weight per ingot 400 lbs.
Size of ingot 60" x 12" 1/8" x 1 3/4"
Assay passing tol. on ingot _____
Diameter of cut blank .695
Thickness of cut blank .0379
Diameter of upset blank .687
Edge thickness upset blank .045
Pieces cut across strip 15
Pieces cut at one stroke 18
Annealing temperature .1500
% rejects, automatic scales _____
% rejects if reviewed _____
% good coins from ingots 57 %
No. pieces per bag 10,000
Weight tol., M pieces _____
Date shipped _____

Government PHILIPPINE

No. Pieces 60,000,000

Date order received March 1971

Was master die furnished No-

Mint where coined Denver

Was master die returned

Denomination 25 Sentimo

Number molts made 2,385

Date coinage started 4/11/71

No. molts delivered to Coiner 2,385

Date coinage completed August 11, 1971

Ounces per molt 5,800

Cost per M

No. ingots per molt 1

Alloy German Silver 70% Copper
18% Zinc, 12% Nickel

Weight per ingot 400 lbs.

Weight per coin 61.73 ± 3 Grains

Size of ingot 60" x 12" 1/8" x 1 3/4"

Weight tolerance ± 3 Grains

Assay passing tol. on ingot

Fineness Tol.

Diameter of cut blank .827

Diameter .825 Tol.

Thickness of cut blank .053

Thickness .065 Tol.

Diameter of upset blank .809

Reeded edge Yes-

Edge thickness upset blank .065

Plain edge -

Pieces cut across strip 10

Lettered edge -

Pieces cut at one stroke 14

Wastage allowed per M

Annealing temperature 1500°

Turn - standard or medal Standard

% rejects, automatic scales

Year (dated) 1971

% rejects if reviewed

Mint mark

% good coins from ingots 59.5%

Was sample coin submitted Yes

No. pieces per bag 4,000

Was sample strike approved

Weight tol., M pieces

Die average

Obv. 216,000

Rev. 184,000

Remarks:

Upset blanks in U. S. Cent groove, but had to have a lead put in segments
Started out stamping dual, but collars would break so stamped most of order with
single collars.

Date shipped

R & C

Government Philippine

No. Pieces 10,000,000

Date order received Sept 26, 1969

Mint where coined Denver

Denomination 25 Centavo

Date coinage started 10-19-69

Date coinage completed 11-10-69

Cost per M _____

Alloy German Silver, 70% Copper
18% Zinc, 12% Nickel

Weight per coin 61.73 ± 3 Grains

Weight tolerance _____

Fineness _____ Tol. _____

Diameter .830 Tol. _____

Thickness .067 Tol. _____

Reeded edge Yes

Plain edge ~~Yes~~

Lettered edge No

Wastage allowed per M _____

Turn - standard or medal Standard

Year (dated) 1969

Mint mark No

Was sample coin submitted Yes

Was sample strike approved Yes

Finished stamping 11-6-69
~~Not shipped~~

Was master die furnished No

Was master die returned No

Number melts made 322-15 Scrapped = 307

No. melts delivered to Coiner 307

Ounces per melt 5800

No. ingots per melt 1

Weight per ingot 400 lbs.

Size of ingot 60" X 12 1/8" X 3/4"

Assay passing tol. on ingot _____

Diameter of cut blank .827

Thickness of cut blank .053

Diameter of upset blank .809

Edge thickness upset blank .067

Pieces cut across strip 10

Pieces cut at one stroke 14

Annealing temperature 1550°

% rejects, automatic scales _____

% rejects if reviewed _____

% good coins from ingots 60.3%

No. pieces per bag 4000

Weight tol., M pieces 129 oz.

Remarks:

Obv. Die Average 270,835

Rev. Die Average 458,160

Recovery Per Ingot 3482.03

US Nix Upsetting

US Nix punch used



DEPARTMENT OF THE TREASURY

WASHINGTON, D. C. 20220

RECEIVED

JUL 25 1974

OFFICE OF
DIRECTOR OF THE MINTOFFICE OF
SUPERINTENDENT
U. S. MINT AT DENVER

July 22, 1974

Superintendent, United States Mint, Philadelphia, Pennsylvania
 Superintendent, United States Mint, Denver, Colorado
 Officer in Charge, United States Assay Office, San Francisco, CA

This letter provides a summary of plans for the 1974 Philippine
 Coin Production Program.

Trial strikes for the six P.L. coins are planned for the week of
 July 22 at the Philadelphia Mint.

Striking of the coins is planned for the fourth quarter of CY
 1974, and may need to be carried into the early part of CY 1975.

Coinage materials will be acquired from several sources as
 further detailed in this summary.

The following table outlines source of coinage strip and ident-
 ifies the field office responsible for striking the coins.

<u>DENUM</u>	<u>QTY</u>	<u>QTY. OF STRIP (lbs.)</u>	<u>SOURCE OF STRIP</u>	<u>STRIP MATERIAL</u>	<u>COIN PRODUCTION OFFICE</u>
1 Centavo	60,000,000	130,000	To Be Purchased	5005 Aluminum 60/40	Phila. Mint
5 Centavo	10,000,000	110,400	Anacosta	Brass 12%Ni-18Zn	Denver Mint
10 Centavo	10,000,000	89,500	Phila. Mint	Nickel-Silver	Denver Mint
25 Centavo	5,000,000	90,000	Phila. Mint	"	SFAO
50 Centavo	5,000,000	177,000	Phila. Mint	"	Denver Mint
1 Peso	60,000,000 (TOTAL)				
	34 30,000,000	1,500,000	Phila. Mint	"	Denver Mint
	26 26,000,000	1,500,000	MRM Industries	"	SFAO 3/2 each
Proof Sets	10,000				SFAO



Training Div
 Asst. Dir.
 Coin

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Specific responsibility of each field office on this program is outlined as follows:

PHILADELPHIA MINT

- Conduct TRIAL STRIKES during the week of July 22 or soon thereafter.
- Provide COINAGE DIES and COIN BAGS as required and as orders are placed by the field offices.
- Complete STRIP FABRICATION and BLANK FABRICATION as follows:
 - 10-Centavo strip ($.038 \pm .0015$ gage x $11 \frac{15}{16}$ " width)
 - 88,500 lbs. required.
 - 8,720 lbs. completed and on hand
 - 79,780 lbs. to be completed and the total quantity shipped to the Denver Mint about August 15.
 - 25-Centavo strip ($.054 \pm .0015$ gage x $11 \frac{15}{16}$ " width)
 - 90,000 lbs. required. A quantity of 102,570 lbs. has been completed and shipped to the SFAO.
 - 50-Centavo strip ($.063 \pm .0015$ gage x $11 \frac{7}{16}$ " width)
 - 177,000 lbs. required. Complete the total quantity and ship to the Denver Mint about August 15.

Upon completion of fabrication of the above coinage strip, proceed on the fabrication of 1-Peso Blanks as follows:

- 1-Peso strip required ($.0735 \pm .0015$ gage x $11 \frac{7}{8}$ " width)
 - 1,500,000 lbs. = 1,050,000 lbs. blanks
- Blank Specifications: Weight 14.5 grams $\pm 4\%$
 - Cut Diameter $1.328'' \pm .003$
 - Gage $0.0735 \pm .0015''$
 - 70% Cu, 12% Ni, 18% Zn

Blanks to be cut only, with no anneal or cleaning. Expected completion date October 31.

- Complete Coinage of 1-Centavo Coins from purchased 5005 Aluminum strip ($.0400$ gage x $9 \frac{1}{4}$ " width), including the procurement of boxes and packaging thereof for shipment, in accordance with previous instructions.
- Furnish 20,000 one-Centavo cut blanks to the SFAO for use in proof coin production.

DENVER MINT

- Will receive 1-Peso blanks, cut only, from MRM Industries and/or the Philadelphia Mint. At this time it is believed MRM shipments will be via wooden crates at about 350 lbs. Philadelphia Mint blanks will be via 55 gallon drums at about 3,000 lbs. (30,000,000 production level).
- Receive coinage strip for 5, 10, and 50 Centavo, and process into coins.
- Box and package for shipment in accordance with previous instructions.
- Ship 20,000 each 5, 10, and 50 Centavo blanks to the SFAO for use in making proof coins.

SFAO

Receive 1-Peso blanks, cut only, as outlined above for the Denver Mint (30,000,000 production level).

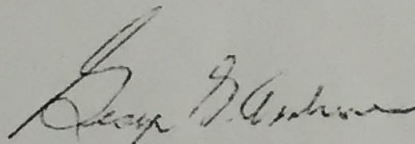
Receive 25-Centavo strip and process into coins.

Complete the production of 10,000 P.I. proof coin sets. The six coin sets are planned to be packaged in Mylar, utilizing an existing six-pocket set of heat rolls.

It is to be noted that an early program for blanking the Nickel-Silver coinage strip by the SFAO and Denver Mint will afford the opportunity to return the blanking scrap to the Philadelphia Mint for reuse.

BLANK 10 & 50 CENTAVO STRIP EARLY TO RETURN NICKEL-SILVER
SCRAP TO PHILA.

Sincerely,



George G. Ambrose
Assistant Director for Production

Government PHILIPPINE

No. Pieces 30,000,000

Date order received <u>February 1972</u>	Was master die furnished <u>NO</u>
Mint where coined <u>Denver</u>	Was master die returned <u>X</u>
Denomination <u>50 Centimos</u>	Number molts made <u>2604</u>
Date coinage started <u>2-8-73</u>	No. molts delivered to Coiner <u>2604</u>
Date coinage completed <u>4-3-73</u>	Ounces per melt <u>5800</u>
Cost per M _____	No. ingots per melt <u>1</u>
Alloy <u>70% Cu - 18% Zinc - 12% Nickel</u>	Weight per ingot <u>400 lbs.</u>
Weight per coin <u>123.46 Grains</u>	Size of ingot <u>60"X12 1/8"X3/4"</u>
Weight tolerance <u>+ 5 Grain</u>	Assay passing tol. on ingot _____
Fineness _____ Tol. _____	Diameter of cut blank <u>1.080 - 1.084</u>
Diameter <u>1.083</u> Tol. <u>+ .003</u>	Thickness of cut blank <u>.0625 + .002</u>
Thickness <u>.077</u> Tol. <u>+ .005</u>	Diameter of upset blank <u>1.062</u>
Reeded edge <u>YES</u>	Edge thickness upset blank <u>.075</u>
Plain edge _____	Pieces cut across strip <u>9</u>
Lettered edge _____	Pieces cut at one stroke <u>10</u>
Wastage allowed per M _____	Annealing temperature <u>1400°F</u>
Turn - standard or medal <u>Standard</u>	% rejects, automatic scales _____
Year (dated) <u>1972</u>	% rejects if reviewed _____
Mint mark _____	% good coins from ingots <u>52%</u>
Was sample coin submitted <u>Yes</u>	No. pieces per bag <u>3,000</u>
Was sample strike approved _____	Weight tol., M pieces _____

DIE LIFE

300,000strikes - Rev. Date shipped _____

360,000strikes - Qbv. _____

Remarks:

Used quarter U.S. upsetting, stamped on standard presses, single. No problems except the edge thickness was changed from 1971 to 1972 from .075 to .077. The coin stamped would be under tolerance, because there was no change in the die.

Government PHILIPPINE

No. Pieces 21,504,000

Date order received March - 1971
Mint where coined Denver
Denomination 5 Sentimos
Date coinage started April 7, 1971
Date coinage completed April 28, 1971
Cost per M _____
Alloy Brass *60% Cu. 40% Zn*
Weight per coin 2.5
Weight tolerance ± 0.3 grains
Fineness _____ Tol. _____
Diameter .7244 Tol. _____
Thickness .0571 Tol. _____
Reeded edge No
Plain edge Yes
Lettered edge No
Wastage allowed per M _____
Turn - standard or medal Standard
Year (dated) 1970
Mint mark None
Was sample coin submitted Yes
Was sample strike approved _____
Die Mileage- _____

Rev.-268,800

Obv.-202,868

Date shipped _____

Remarks: Presses-3 Conventionals-1-K-200

Scrapped

Remilled 24 Hrs. of upsetting-upset diameter too large to start. Poor press production for the first 24 hrs. upset Blanks in a cent groove with a lead in segments.

Ruined 53,083 ozs. - had to scrap annealed too hot- 1450° warped.

Was master die furnished No

Was master die returned _____

Number melts made Commercial Strip

No, melts delivered to Coiner _____

Ounces per melt _____
PCS. _____

~~NO. INGOTS PER MOLT~~
Blanks Cut _____

Weight ~~per melt~~ _____

Purchased 175,689 pounds
~~2,562,131 ozs.~~

Assay passing tol. on ingot _____

Diameter of cut blank .730

Thickness of cut blank .043

Diameter of upset blank .715

Edge thickness upset blank .057

Pieces cut across strip 9 & 8

Pieces cut at one stroke 17

Annealing temperature 1000°

% rejects, automatic scales _____

% rejects if reviewed 34,318 ozs.

% good coins from ingots _____

No. pieces per bag 8,000

Weight tol., M pieces _____

Government Philippines

No. Pieces 150,000,000

Date order received February 1972 Was master die furnished No
Mint where coined Denver, Colorado Was master die returned - 0 -
Denomination One Peso Number molts made 20,834
Date coinage started April 1972 No, molts delivered to Coiner 20,384
Date coinage completed March 1973 Ounces per melt 5,800
Cost per M _____ No. ingots per melt 1
Alloy 70% Copper, 18% Zinc, 12% Nickel Weight per ingot 400 lbs.
Weight per coin 223.8 Gr. Size of ingot 60"X12 1/8"X1 3/4"
Weight tolerance ±9.0 Gr. Assay passing tol. on ingot _____
Fineness _____ Tol. _____ Diameter of cut blank 1.328 + .003
Diameter 1.319 Tol. -.003 Thickness of cut blank .0736
Thickness .088 Tol. + .005
- .003 Diameter of upset blank 1.298 max.
Reeded edge Yes Edge thickness upset blank .088
Plain edge - 0 - Pieces cut across strip 4
Lettered edge - 0 - Pieces cut at one stroke 8
Wastage allowed per M - 0 - Annealing temperature 1450°
Turn - standard or medal Standard % rejects, automatic scales _____
Year (dated) 1972 % rejects if reviewed 3,000,000 pcs.
Mint mark No In House 52 1/2%
% good coins from ingots Comm. 62 1/2%
Was sample coin submitted Yes No. pieces per bag 1,500 pcs.
Was sample strike approved - 0 - Commercial strip bought _____
Weight 1.014,759#
Date shipped March 7, 1973

Remarks: Die Average Obv. 209,790
Rev. 184,049

Poor die life on Columbia presses, good on regular presses.
Started production on Columbia presses --- collars would break and
made a very poor coin. Changed to Regular presses, good results with
dies, and fair with collars. Stamping Pesos on regular presses resulted
in above normal amount of cup and ball work for such a large order. The
stamping caused a lot of machine shop work on the presses.



DEPARTMENT OF THE TREASURY

WASHINGTON, D.C. 20220

RECEIVED

MAR 17 1975

MAR 14 1975
42 S
SUPERINTENDENT
MINT AT DENVER

OFFICE OF
DIRECTOR OF THE MINT

Superintendent, United States Mint, Philadelphia, Pennsylvania
Superintendent, United States Mint, Denver, Colorado
Officer in Charge, United States Assay Office, San Francisco, Calif.

Our plans are firm on the manufacture of a total of 275,000,000 Philippine 1975-dated circulating coins, as follows:

Denom.	Quantity	Alloy	Wt. (Grams)	Dia. (mm)	Edge Thickness (mm)
1 Centavo	105,000,000	95Al/5Ni	0.49	15.25	1.36
5 Centavo	90,000,000	60Cu/40Zn	2.50	18.40	1.45
10 Centavo	60,000,000	70Cu/10Zn/12Ni	2.00	17.90	1.24
25 Centavo	10,000,000	"	4.00	21.00	1.75
50 Centavo	5,000,000	"	8.00	27.50	1.96
1 Peso	5,000,000	"	14.50	33.50	2.24

1 and 5 Centavo plain edge; 10 Centavo through 1 Peso reeded edge.

Tolerances: Diameter ± 0.076 mm
Edge Thickness $+0.127$ mm -0.076 mm
Weight $\pm 4.0\%$

The Philadelphia Mint will be responsible for pre-trial die work, trial striking each denomination and providing all working dies, reeded collars, and coin bags. The SFAO and Denver Mint will be involved in the production of these coins to the extent outlined.

Each field office is assigned program accomplishment in accordance with the following outline of work.

PHILADELPHIA MINT

1. Trial strike each denomination.
Specifications are:

	1 Centavo	5 Centavo	10 Centavo	25 Centavo	50 Centavo	1 Peso
Cut Blank						
Diameter	0.604"	0.730"	0.693"	0.827"	1.032"	1.328"
Thickness	0.040"	0.043"	0.038"	0.053"	0.063"	0.0735"



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	1	5	10	25	50	1
	<u>Centavo</u>	<u>Centavo</u>	<u>Centavo</u>	<u>Centavo</u>	<u>Centavo</u>	<u>Peso</u>
<u>Upset Blank</u>						
Diameter	0.594"	0.715"	0.687"	0.810"	1.062"	1.298"
Thickness	0.045"	0.057"	0.045"	0.066"	0.075"	0.088"

Tolerances:

Cut Blank

Diameter: All $\pm$ 0.003
 Thickness: 1 Centavo through 50 Centavo $\pm$ 0.0015
 1 Peso $\pm$ 0.0020

Upset Blank

Diameter: All $\pm$ 0.001

Blanks for trial striking will be provided from the stock of material remaining from the recently completed Philippine order for 150 million coins, as follows:

From Philadelphia - 1 Centavo - 200 upset blanks
 From Denver - 5 Centavo - 200 upset blanks
 10 Centavo - 200 upset blanks
 1 Peso - 200 upset blanks
 From San Francisco - 25 Centavo - 200 upset blanks
 50 Centavo - 200 upset blanks

It is understood collars for each denomination are on hand at the Philadelphia Mint.

- You are requested to proceed with the manufacture and shipment of reeded collars and coin bags to the SFAO in accordance with the following schedules:

COLLARS

<u>Denom.</u>	<u>Type</u>	<u>Total Required</u>	<u>From Denver</u>	<u>To be Mfg'd by Phila.</u>	<u>Delivery</u>
10 Centavo	Dual	65	0	65	1/2 by 6/1/75; bal. 7/1/75
25 Centavo	Single	12	0	12	all by 6/1/75
50 Centavo	Single	12	12	0	all by 6/1/75
1 Peso	(none required)				

The 25 Centavo Collars will be Mint Standard, and the 10 Centavo Collars will be Mint Standard with 1.210" center distance.

COIN BAGS

<u>Denomination</u>	<u>Quantity</u>	<u>Delivery</u>
1 Centavo	10,500	1/2 by 5/1/75; bal. by 8/1/75
5 Centavo	11,250	1/2 by 5/1/75; bal. by 8/1/75
10 Centavo	6,000	by 5/15/75
25 Centavo	2,500	by 5/15/75
50 Centavo	2,500	by 7/1/75
1 Peso	5,000	by 7/1/75

Coin Bags are to be marked with the following data:

<u>Denomination</u>	<u>Number Pieces</u>	<u>Value</u>
1 Centavo	10,000	100 Peso
5 Centavo	8,000	400 Peso
10 Centavo	10,000	1,000 Peso
25 Centavo	4,000	1,000 Peso
50 Centavo	2,000	1,000 Peso
1 Peso	1,000	1,000 Peso

3. You are requested, upon approval of trial strikes, to proceed with the manufacture and shipment of dies to the SFAO as follows:

<u>Denom.</u>	<u>Type</u>	<u>Obv.</u>	<u>Rev.</u>	<u>Required Delivery</u>
1 Centavo	Dual	471 (39)	265	1/4 order per month-start 5/15/75
5 Centavo	Dual	1500	900	1/4 order per month-start 5/15/75
10 Centavo	Dual	315	300	1/2 order by 6/1/75; bal. by 7/1/75
25 Centavo	Dual	0	30	by 6/15/75
50 Centavo	Single	0 (67)	20	by 7/15/75
1 Peso	Single	0 (50)	45	by 7/15/75

The quantities in parentheses represent unused dies remaining from the recently completed order, which will be shipped to the SFAO by the Philadelphia Mint (1 Centavo) and Denver Mint (50 Centavo and 1 Peso). Other quantities are to be furnished by the Die Manufacturing Division. The 1, 5, 10, and 25 Centavo dies are to be Mint Standard, dual type, and the 50 Centavo and 1 Peso will be Mint Standard.

4. Effect truck shipment of the approximately 12,500,000 upset 1 Centavo blanks on hand, weighing 13,925 pounds, the week of April 7, 1975. Notify Mr. Voss by phone on date of shipment. It is understood blanks have been placed in 55 gallon drums, strapped four to a pallet, and that the shipment will consist of 8 pallets; gross weight 15,965 lbs. All arrangements for shipment are to be made by the Philadelphia Mint.

5. Ship as soon as practical the following 1 Centavo, Bliss 6K-200 tooling to be used by the SFAO and returned. Also arrange through the die shop for shipment of the indicated obverse dies.

- 14 Collars - 1.210 center distance
- 39 Obverse Dies - Mint Standard, dual type
- 14 Tubes - Mint Standard (for use on 1.210 center distance collars)
- 14 pairs of feeders
- 8 sets of tracks

DENVER MINT

1. Ship the following material to the Philadelphia Mint as soon as practical, for use in trial strikes.

- 200 - Five Centavo, Upset Blanks
- 200 - Ten Centavo, Upset Blanks
- 200 - One Peso, Upset Blanks

2. Receive and blank the following coinage strip using existing blanking die sets.

	50 Centavo	1 Peso
Alloy	70Cu/18Zn/12Ni	70Cu/18Zn/12Ni
Quantity	15,000 lbs.	130,000 lbs.
Gauge ($\pm$ 0.0015)	0.063"	0.0735"
Width ($\pm$ 1/32)	11 7/16"	11 7/8"
Delivery	wk. of 6/9/75	wk. of 6/16/75
Yield	69%	70%
Est. No. of Blanks	4,325,000	2,735,000
Est. lbs. of Blanks	79,350	91,000

3. Ship cut blanks to the SFAO and return blanking scrap to the strip fabricator in containers to be provided by him. It is suggested 50 gallon drums, with clamp-type covers, be purchased and utilized in the shipment of all blanks to the SFAO, in order to not involve Mint-type tanks in their shipment.

4. Ship the following strip and blanks to the SFAO.

	<u>Strip</u>	<u>Cut</u>	<u>Blanks</u>	<u>Upset</u>	<u>Required Delivery</u>
5 Centavo	19,761 lbs.	---		3,782 lbs.	Wk. of 4/28/75
10 Centavo	45,449 lbs.	---		1,988 lbs.	Wk. of 4/28/75
1 Peso	---	26,020 lbs.		3,092 lbs.	With 1 Peso blanks to be cut from strip

Pursuant to Mr. Collicelli's conversation with Mr. Voss, the new 5 and 10 Centavo blanking die sets being designed and fabricated by the SFAO will accommodate the above strip which is 11 15/16" in width, although the yield will be less than optimum.

5. Ship the following dies and collars to the SFAO.

	<u>Obv. Dies</u>	<u>Collars</u>
50 Centavo	67	12 new 5 used
1 Peso	54	50 used

The small quantity of 5 Centavo and 10 Centavo obverse dies on hand at the Denver Mint may be destroyed, inasmuch as their being non-standard type, are not adaptable for use at the SFAO.

SAN FRANCISCO ASSAY OFFICE

1. Manufacture 275,000,000 Philippine 1975 dated coins of the following denominations:

1 Centavo	-	105,000,000
5 Centavo	-	90,000,000
10 Centavo	-	60,000,000
25 Centavo	-	10,000,000
50 Centavo	-	5,000,000
1 Peso	-	5,000,000
		<u>275,000,000</u>

2. Production is scheduled to commence on May 1, with completion no later than December 31, 1975.
3. Proceed with the design and fabrication of new blanking die sets for the 1, 5, and 10 Centavo denominations in accordance with specifications and instructions detailed in our letter of February 11, 1975.

4. In addition to the blanks and strip to be furnished by the Philadelphia and Denver Mints, as detailed above, you will also receive the following quantities of strip:

	<u>1 Centavo</u>	<u>5 Centavo</u>	<u>10 Centavo</u>
Alloy	5005 Al	60Cu/40Zn	70Cu/18Zn/12Ni
Quantity	184,000 lbs.	725,000 lbs.	375,000 lbs.
Gauge ($\pm$ 0.0015)	0.040	0.043	0.038
Width ($\pm$ 1/32)	11 3/8"	11 7/8"	11 13/16"
Delivery	wk. of 4/28/75	200,000 per wk. beg. 4/28/75	200,000 per wk. beg. 4/28/75
Expected Yield	65%	75%	74%

	<u>25 Centavo</u>
Alloy	70 Cu/18 Zn/12 Ni
Quantity	80,000 lbs.
Gauge ($\pm$ 0.0015)	0.053
Width ($\pm$ 1/32)	11 15/16"
Delivery	wk. of 5/26/75
Expected Yield	68%

5. Your orders for dies, reeded collars, and coin bags have been approved and furnished to Philadelphia. Proceed with the acquisition of boxes and skids.
6. You are responsible for providing non-reeded collars for the 1 and 5 Centavo, having noted that the Philadelphia Mint will furnish 14 collars for the 1 Centavo.
7. Packaging of Coins

	<u>Coins</u>	<u>Bags</u>	<u>Total</u>	<u>Total</u>
	<u>Per Bag</u>	<u>Per Box</u>	<u>Bags</u>	<u>Boxes</u>
1 Centavo	10,000	2	10,500	5,250
5 Centavo	8,000	2	11,250	5,625
10 Centavo	10,000	2	6,000	3,000
25 Centavo	4,000	2	2,500	1,250
50 Centavo	2,000	3	2,500	834
1 Peso	1,000	3	5,000	1,667
			<u>37,750</u>	

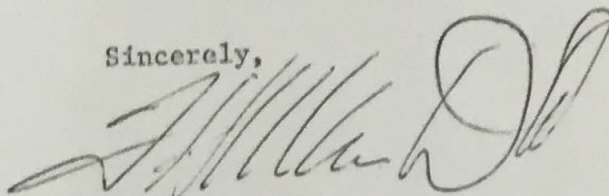
Each box will be nailed shut, banded, with two steel straps and secured on skids. The number of boxes per skid is to be determined by the SFAO.

Upon the P.I. advising us as to box markings, you will be informed of same.

All coins manufactured under this program are F.O.B loading dock, the San Francisco Assay Office.

It is likely we will be requested to manufacture 1975 P.I. Proof Sets, and thus have made allowance for up to 100,000 sets in strip procurement. Upon completion of this program, you are to retain all good blanks, unused dies - obverse and reverse, unused collars, and other P.I. coin related materials and tooling for use on future Philippine orders.

Sincerely,

A handwritten signature in dark ink, appearing to read 'F.H. MacDonald', with a large, stylized flourish at the end.

F.H. MacDonald
Acting Director of the Mint

Memorandum

Coordinator's Copy

TO : Melting, Coining, Mechanical, Assay Divisions
and Storeroom

DATE: March 12, 1974

FROM : Cost Accounting

SUBJECT: Job Numbers to be used for Manufacture of Philippine 5 Centavo (10,000,000
Pes.), 10 Centavo (10,000,000 Pes.), 50 Centavo (5,000,000 Pes.) and 1 Peso
(33,000,000 Pes.) 122,000 lbs 210,000# 53,000#

Dept.	No.	Charge To	Denomination
Process Weigh	8100	8165	5 Centavo
		8166	10 Centavo
		8167	50 Centavo
		8168	1 Peso
Blanking	8200	8265	5 Centavo
		8266 T-0379	10 Centavo 6950 2087.2
		8267	50 Centavo
		8268	1 Peso
Material Handling	7800	7865-3	5 Centavo Strip
		7865-4	5 Centavo Scrap
		7866-3	10 Centavo Strip
		7866-4	10 Centavo Scrap
		7867-3	50 Centavo Strip
		7867-4	50 Centavo Scrap
		7868-3	1 Peso Strip
		7868-4	1 Peso Scrap
Annealing	8300	8365	5 Centavo
		8366	10 Centavo
		8367	50 Centavo
		8368	1 Peso
Upsetting	8500	8565	5 Centavo
		8566	10 Centavo
		8567	50 Centavo
		8568	1 Peso
Selecting	8800	8865-2	5 Centavo Blanks
		8865-3	5 Centavo Coin
		8866-2	10 Centavo Blanks
		8866-3	10 Centavo Coin
		8867-2	50 Centavo Blanks
		8867-3	50 Centavo Coin
		8868-2	1 Peso Blanks
		8868-3	1 Peso Coin

March 12, 1974

Subject: Job Numbers to be used for Manufacture of Philippine 5 Centavo (10,000,000 Pes.), 10 Centavo (10,000,000 Pes.), 50 Centavo (5,000,000 Pes.) and 1 Peso (33,000,000 Pes.)

<u>Dept.</u>	<u>No.</u>	<u>Charge To</u>	<u>Denomination</u>
Stamping	8600	8665	5 Centavo
		8666	10 Centavo
		8667	50 Centavo
		8668	1 Peso
Counting	8700	8765	5 Centavo
		8766	10 Centavo
		8767	50 Centavo
		8768	1 Peso
Cash, Counting & Shipping	1300	1365-1	5 Centavo, Boxing
		1365-2	5 Centavo, Pallet.&Ship.
		1366-1	10 Centavo, Boxing
		1366-2	10 Centavo, Pallet.&Ship.
		1367-1	50 Centavo, Boxing
		1367-2	50 Centavo, Pallet.&Ship.
		1368-1	1 Peso, Boxing
		1368-2	1 Peso, Pallet.&Ship.
Assay	3500	8265	5 Centavo Strip
		8266	10 Centavo Strip
		8267	50 Centavo Strip
		8268	1 Peso Strip
Mechanical	6000	8265	5 Centavo Die Sets, Sharpening, etc.
		8266	10 Centavo Die Sets, Sharpening, etc.
		8267	50 Centavo Die Sets, Sharpening, etc.
		8268	1 Peso Die Sets, Sharpening, etc.
		8565	5 Centavo Segments
		8566	10 Centavo Segments
		8567	50 Centavo Segments
		8568	1 Peso Segments
		8665	5 Centavo Grind Dies
		8666	10 Centavo Grind Dies
		8667	50 Centavo Grind Dies
		8668	1 Peso Grind Dies

December 7, 1972

Delano
RECEIVED

DEC 19 1972

OFFICE OF
SUPERINTENDENT
U. S. MINT AT DENVER

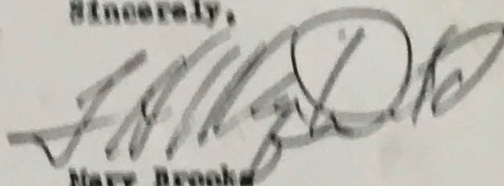
Superintendent, United States Mint, Philadelphia, Pa. 19106
✓ Superintendent, United States Mint, Denver, Colo. 80204
Officer in Charge, United States Assay Office, San Francisco, Calif. 94102

Attached are new tolerances for weight, diameter, and thickness of Philippine coinage.

These tolerances are similar to those of U. S. coinage and replace any existing specifications.

Thank you for your cooperation.

Sincerely,



Mary Brooks
Director of the Mint

Enclosure

cc: A.J. Goldman
G.G. Ambrose
R.G. Cahoon
H.F. Johnson

24 Jan 1973
Copy to Mr. W.
GEM:sel

AJO

GGA

RCC

F.H. MacD

RECEIVED

DEC 13 1972

OFFICE OF
SUPERINTENDENT

U. S. MINT AT DENVER

PHILIPPINE COINS - STANDARD AND TOLERANCE

	<u>WEIGHT</u>	<u>DIAMETER</u>	<u>THICKNESS</u>
1 Sentimo	7.6 - grains ± 0.30 - grains	.600 - inches ± .003 - inches	.054 - inches + 0.005 - inches - 0.003 - inches
5 Sentimos	38.6 - grains ± 1.5 - grains	.724 - inches ± .003 - inches	.057 - inches + 0.005 - inches - 0.003 - inches
10 Sentimos	30.9 - grains ± 1.2 - grains	.579 - inches ± .003 - inches	.049 - inches + 0.005 - inches - 0.003 - inches
25 Sentimos	61.7 - grains ± 2.5 - grains	.827 - inches ± .003 - inches	.069 - inches + 0.005 - inches - 0.003 - inches
50 Sentimos	123.4 - grains ± 5.0 - grains	1.083 - inches ± .003 - inches	.077 - inches + 0.005 - inches - 0.003 - inches
1 Piso	223.8 - grains ± 9.0 - grains	1.319 - inches ± .003 - inches	.088 - inches + 0.005 - inches - 0.003 - inches

12/6/72

Bureau Laboratory



OFFICE OF THE
SUPERINTENDENT

THE DEPARTMENT OF THE TREASURY

UNITED STATES MINT

PHILADELPHIA, PA. 19106

March 1, 1972

RECEIVED

MAR 3 - 1972

OFFICE OF
SUPERINTENDENT
U. S. MINT AT DENVER

Mrs. Betty Higby
Superintendent
United States Mint
320 W. Colfax St.
Denver, Colo. 80204

Dear Mrs. Higby:

Enclosed for your examination are two (2) trial strikes of the Philippine 1 Piso coin, and six (6) cut and six (6) upset blanks having the following nominal specifications:

	(changed) Weight	OK Diameter	(changed) Thickness
1 Piso Coin	230 grains	1.319"	.090"
Cut Blank	230 grains	1.328" + .001	.075"
Upset Blank	230 grains	1.298"	.091"

Sincerely,

Frank E. Campbell

Frank E. Campbell
Acting Superintendent

Enclosure

Recd 3/3/72

march - 22 - 1103-

Standard

• Coin Thickness -.088

upset blank thickness -.088

wt - 223.76 grains - 14.50 grains.

Blank Thickness - .073525

1 Piso
Dia 1.328 + .001
thickness .0736

REC

Government Philippine

No. Pieces 40,000,000

Date order received Sept. 26, 1969
Mint where coined Denver
Denomination 10 Centavo
Date coinage started 9-26-69
Date coinage completed 11-17-69
Cost per M German Silver - 70% Copper,
Alloy 18% Zinc, 12% Nickel
Weight per coin 30.87 ± 2 Grains
Weight tolerance _____
Fineness _____ Tol. _____
Diameter .705 Tol. _____
Thickness .047 Tol. _____
Reeded edge Yes
Plain edge _____
Lettered edge _____
Wastage allowed per M _____
Turn - standard or medal Standard
Year (dated) 1969
Mint mark None
Was sample coin submitted Yes
Was sample strike approved Yes
Finished Stamping 11-15-69
~~Scrapped~~

Was master die furnished No
Was master die returned No
Number melts made 761-16 Scrapped=745
No, melts delivered to Coiner 745
Ounces per melt 5800
No. ingots per melt One
Weight per ingot 400 lbs.
Size of ingot 60" X 12 1/8" X 1 3/4
Assay passing tol. on ingot _____
Diameter of cut blank .695
Thickness of cut blank .0379
Diameter of upset blank .687
Edge thickness upset blank .046
Pieces cut across strip 15
Pieces cut at one stroke 18
Annealing temperature 1350°
% rejects, automatic scales _____
% rejects if reviewed _____
% good coins from ingots 60.9%
No. pieces per bag 10,000
Weight tol., M pieces 63 oz.

Remarks:

Obv. Die Average 197,884
Rev. Die Average 213,569
Recovery Per Ingot 3591 oz.

US Dime Upsetting
US Dime Collar Used
US Dime Punch Used

1-Pass - PHILIPPINE

3-N7N

Rec. @ .220

GERMAN A.G.

PASS

DIAL.

GAUGE

X-RAY

1

220

.185-.190

2

195

.165

3

175

.145

ANNEAL.

4

155

.110

5

140

.090

6

135

.080

SALFOT- 125

7

135

.0736

115⁺ 1/2REC-072⁺GANTHO-074⁺

DIA-1.328

WT-223.86 gms

10-18-24

1 Peso
Phil.

M.B.M.

Philippine Peso

11-3-75

6 Blanks

1.328 Dia.

.0735 Thickness

3-27-72

1-PESO

Philippine

Thick - .0736

Dia. - 1.328

wt. - 223.76 grs.

Philippine
10 Centavo

Guage Fin Blank

~~.035~~
.038

Blank Dia. .695

WT 30.865 grains

+ 2 grains = T

Standard
Blank

Philippine

5 Centavo

Guage Fin Blank

.043

Blank dia .730

WT 38.58 gr.

± 3 grains = T

X-ray .069^{1/2}

10 Centavo 1.30

Dia. .827

Thick .053

25

Centavo

Philippine

61.73 gr.

10 - 3

50 - Centavo

Philippine

+ or - 5 gr

wt. - 123.46 grs

Dia. 1.080 - 1.084

Thick. .061 - .064

old

192
1
10-

3-27-72
1-PESO
PHILIPPINE
THICK - .0736
Dia. - 1.328
wt - 223.76 grs.

Philippine Peso
11-3-75
6 Blanks
1.328 Dia.
.0735 Thickness

Philippine
10 Centavo
Gauge Fin Blank
~~.035~~
.038
Blank Dia .695
wt 30.865 grain
 $\pm 2 \text{ grains} = T$
1 Standard
Blank

Philippine
5 Centavo
Gauge Fin Blank
.043
Blank dia .730
wt 38.58 gr.
 $\pm 3 \text{ grains} = T$
X-ray .06 gr.

10 Centavo
Dia .827
Thickness .053
25
Centavo
Philippine
61.73 gr.
10 - 3

50 - Centavo
Philippine
+ or - 5 gr
wt. - 123.46 grs
Dia. 1.080 - 1.084
THICK. .061 - .064

11/11

14/11
11/11
11/11

Philippines 4-26-71
50 Centavo

total 10,000,000 Pieces
" 2,570,700 ounces
" 800 Ingots

Diameter 1.0799 to 1.0839

Thickness .0618 To .0642

Weight Per Coin 123.46 grams.

Edge of strip .061 Center of strip .064

Finish schedule

Pass

Gauge

8 max

1

.190

2

.170

3

.145

Annual

4

.110

5

.085

6

.072

111

7

.0635

.098-

11-10-07

PHASE		5. C. TAY 36		Bones
	APC. @	.200		
Pass -	DIAL	GROGK	X-Ray	COILER
1-	210	.190	-	2
2-	180	.150	-	3
3-	160	.130	-	4
		ANNPMB		
4-	130	.087	-	8
5-	110	.073	-	4
6-	92	.057	.22	2 1/2
7-	78	.043	69" $\frac{1}{2}$	4
	72-73			

2. would like.
 3. 1/2 tray covered
 4. at 150 then
 finished.

Government Philippine

No. Pieces 10,000,000

Date order received May 1971

Was master die furnished No

Mint where coined Denver

Was master die returned X

Denomination 50 Sentimos

Number melts made 824

Date coinage started 5-10-71

No. melts delivered to Coiner 824

Date coinage completed 7-20-71

Ounces per melt 5.800

Cost per M

No. ingots per melt 1

German Silver 70% Copper

Alloy 18% Zinc 12% Nickel

Weight per ingot 400 lbs.

Weight per coin 123.46 grains

Size of ingot 60" x 12 1/8" x 3/4"

Weight tolerance + or - 5 grains

Assay passing tol. on ingot

Fineness Tol.

Diameter of cut blank 1.080 to 1.084

Diameter 1.082 Tol. + or - .002

Thickness of cut blank .0625

Thickness .075 Tol. + or - .002

Diameter of upset blank 1.062

Reeded edge Yes-

Edge thickness upset blank .075

Plain edge

Pieces cut across strip 9

Lettered edge

Pieces cut at one stroke 10

Wastage allowed per M

Annealing temperature 1,400° F

Turn - standard or medal Standard

% rejects, automatic scales

Year (dated) 1971

% rejects if reviewed

Mint mark

% good coins from ingots 55%

Was sample coin submitted Yes-

No. pieces per bag 3,000

Was sample strike approved

Weight tol., M pieces

Die Average-

Obverse- 200,000 Strikes Date shipped

Reverse- 232,000 Strikes

Remarks:

Used Quarter Upset - Groove
Single Stamped on Conventional Presses- no problems.

Philippine Blanks Via S.F.

5 Centavos

5,000,000 pieces

0.043 strip gauge

⁶⁰⁹⁶ 40% Copper, ^{40%} 60% Zinc

2.5 grams $\pm$ 3 grams (Blank coin)

38.58089 grams

0.083765 tr. oz.

18.4 MM diameter

0.7244" " (coin ?)

0.730" Dia. blank

181 pcs/lb

S.F. Shipping two 6" blanking dies
allow reg. 1¢ to 5 cents or

10 Centavos

5,000,000 pieces

0.035 strip gauge

70% Copper, 18% Zinc, 12% Nickel

2.0 grams $\pm$ 2 grams (Blank coin)

30.864712 grams

0.06430148 tr. oz.

17.9 MM diameter

0.7047" " (coin ?)

0.695 Dia. blank

226.8 pcs/lb.

Des. reg. for blanking dies

16 air

240 - .185

243 - .173

230 - .162

UNITED STATES GOVERNMENT

Memorandum

TO : M&R Coining, Mechanical & Assay Divisions

DATE: November 9, 1967

FROM : Cost Accounting

SUBJECT: Job Numbers for Philippine 5 & 10 Centavos, Make-Up & Melting thru Blanking Operations - For San Francisco Assay Office

<u>M&R Ingots</u>	Dept.	Job Charge	
	7700	7765	Five Centavo
	7700	7766	Ten Centavo

Coining Division

Rolling Includes - Rolling, Slab Annealing, and Slittering.

	Dept.	Job Charge	
Rolling	8200	8267 R <i>Rolling</i>	Five Centavo
Blanking	8200	8267 B	" "
Rolling	8200	8268 R <i>Rolling</i>	Ten Centavo
Blanking	8200	8268 B	" "

*Process weigh
+
Materials Hand*

Preparation For			
Shipping Costs	8200	8269	Five Centavo
	8200	8270	Ten Centavo

Mechanical Division

	Dept	Job Charge	Job Request
Electricians & Machinists General Maintenance	6000	7704	#7771
Die Sets Charges	6000	8204	#8267 Five Centavo
	6000	8204	#8268 Ten Centavo
Electricians & Machinists General Maintenance	6000	8204	#8269

<u>Assay Division</u>	Dept.	Job Charge	
	3500	7765	Five Centavo
	3500	7766	Ten Centavo



UNITED STATES GOVERNMENT

Memorandum

German Silver

TO : Superintendents of Melting, Coining, Assay,
Cash and Deposits and Mechanical Division

DATE: February 8, 1971

FROM : Cost Accounting Branch

SUBJECT: Job Numbers for Philippine Coins, 50 Centavo, 25 Centavo, 10 Centavo from
Manufactured "In-House" Strip and 5 Centavo from Purchased Strip

<u>Melting:</u>	<u>Dept.</u>	<u>Charge</u>	<u>Denomination</u>
Universal Ingot	7700	7779	Ingot
<u>Process Weighing:</u>	8100	8179	5 Centavo
		8180	10 Centavo
		8181	25 Centavo
		8182	50 Centavo
✓ <u>Rolling:</u> (Includes Slab Annealing) 7900		7980	10 Centavo
		7981	25 Centavo
		7982	50 Centavo
✓ <u>Blanking:</u>	8200	8279	5 Centavo - 730
		8280	10 Centavo - 695
		8281	25 Centavo - 827
		8282	50 Centavo - 1.080-83
		062-064	
<u>Annealing:</u>	8300	8379	5 Centavo
		8380	10 Centavo
		8381	25 Centavo
		8382	50 Centavo
<u>Upsetting:</u>	8500	8579	5 Centavo
		8580	10 Centavo
		8581	25 Centavo
		8582	50 Centavo
<u>Selecting:</u>	8800	8879	5 Centavo
		8880	10 Centavo
		8881	25 Centavo
		8882	50 Centavo
<u>Stamping:</u>	8600	8679	5 Centavo
		8680	10 Centavo
		8681	25 Centavo
		8682	50 Centavo

John Hook

3/27/71

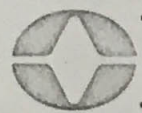
Co. 40 Brass will be
shipped about March 22nd or 23rd
and may leave March 27th

#1 strip will be shipped
early in the week of
March 22nd

John Hook & Geo. Riche
will be here March 29
to witness trials

Other Bad Offerings

March 8	Box for Denver
March 9	" " Phila
March 18	100 " Denver
March 24	500 " Denver

 **lin BRASS**

Rolling & Cutting

UNITED STATES GOVERNMENT

Memorandum

TO : M&R, Coining, Cash & Deposits, Assay, and
Mechanical Divisions

DATE: September 16, 1969

FROM : Cost Accounting

SUBJECT: Job Numbers for Philippine 10 and 25 Centavos coins.

M&R Ingots

Dept.
7700
~~7700~~
~~XXXX~~

Job Charge

7766
~~7766~~ Ingot (10 Centavos
25 Centavos

Coining Division

Rolling & Blanking

Rolling includes - Rolling, Slab Annealing, and Slittering.

	<u>Dept.</u>	<u>Job Charge</u>	
Rolling	8200	8268 R	10 Centavos
Blanking	8200	8268 B	10 Centavos
Rolling	8200	8269 R	25 Centavos
Blanking	8200	8269 B	25 Centavos

Annealing & Blanking

Dept.
8300
8300

Job Charge

8368 10 Centavos
8369 25 Centavos

Upsetting

Dept.
8500
8500

Job Charge

8568 10 Centavos
8569 25 Centavos

Selecting

Dept.
8800
8800
8800
8800

Job Charge

8868-2 10 Centavos
8869-2 25 Centavos
8868-3 10 Centavos
8869-30 25 Centavos

Automatic Weigh

Dept.
8400
8400

Job Charge

8468 10 Centavos
8469 25 Centavos

Stamping

Dept.
8600
8600
8600

Job Charge

8668 10 Centavos
8669 25 Centavos
8668-3 10 Centavos
Collars
8669-3 25 Centavos
Collars
8668-4 10 Centavos Dies
8669-4 25 Centavos Dies

Stores Items

Stores Items

Stores Items

Stores Items



UNITED STATES GOVERNMENT

Memorandum

TO : MSR, Coining, Cash & Deposits, Assay, and
Mechanical Divisions

DATE: September 16, 1969

FROM : Cost Accounting

SUBJECT: Job Numbers for Philippine 10 and 25 Centavos coins.

<u>Counting</u>	<u>Dept.</u>	<u>Job Charge</u>	
	8700	8768	10 Centavos
	8700	8769	25 Centavos

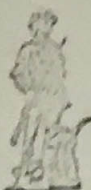
Cash & Deposits Division

Preparation for Shipment

<u>Dept.</u>	<u>Job Charge</u>	
1300	1368	10 Centavos
		Boxes
1300	1369	25 Centavos
		Boxes
1300	1368-1	10 Centavos
		Boxing and
		Weighing
1300	1369-1	25 Centavos
		Boxing and
		Weighing
1300	1370	10 Centavos
		Shipping
1300	1371	25 Centavos
		Shipping

Mechanical Division

<u>Dept.</u>	<u>Job Charge</u>	
6000	8268-4	10 Centavos
		Sharpening &
		Changing Die
		Sets
6000	8269-4	25 Centavos
		Sharpening &
		Changing Die
		Sets
6000	8568-4	10 Centavos
		Segment Adjust-
		ments
6000	8569-4	25 Centavos
		Segment Adjust-
		ments
6000	8668-4	10 Centavos
		Grinding Dies
6000	8669-4	25 Centavos
		Grinding Dies



Philippine Blanks Vol 2

125 Lgts

5 Santaves "4 inch

5,000,000 francs

0.043 strip gauge

70% Copper, 30% Zinc

2.5 grams 12 grams (black)

38.53037 grams

0.083765 t. oz.

18.4 MM diameter

0.7244 " (coin 2)

0.730 Dra. blank

181 per lb.

Shipping two 6" blanking dies

allowing 1% to 5 centimeter

German Silver - 75% Ag

10 Santaves "3 inch

5,000,000 francs

0.035 strip gauge

70% Copper, 18% Zinc, 12% Nickel

2.0 grams 12 grams (black)

30.864712 grams

0.0643048 t. oz.

17.9 MM diameter

0.7047 " (coin 3)

0.675 Dra. blank

226.8 per lb.

Dra. reg. 10" blanking dies

Keep all also by weight coils in marked & separate

(The Centavo Standard weights are in green cup board)

M & K

Coiner

UNITED STATES GOVERNMENT

Memorandum

TO : Superintendents of Melting, Coining, Assay, DATE: June 30, 1970
and Mechanical Divisions

FROM : Cost Accounting Branch

SUBJECT: Job Numbers for Philippine 25 Centavo Blanks *German Silver*

Melting

<u>Dept.</u>	<u>Charge</u>
7700	7794

Process Weigh

<u>Dept.</u>	<u>Charge</u>
8100	8194

Rolling

<u>Dept.</u>	<u>Charge</u>
7900	7994

Blanking

<u>Dept.</u>	<u>Charge</u>
8200	8294

Counting

<u>Dept.</u>	<u>Charge</u>
8700	8779

Material Handling

<u>Dept.</u>	<u>Charge</u>
7700	7794
8700	8794

Assay

<u>Dept.</u>	<u>Charge</u>
3500	7794

Ingots or Scrap
Blanks, Tanks, etc.

Ingots

Cut Metal Dia. .827

Thickness .053

edge of strip .050 to .055

Weight 61.73 Grain $\pm$ 3g

*Started rolling
7-8-70*

Includes Rolling, Slab
Annealing, etc.





TREASURY DEPARTMENT

UNITED STATES MINT

DENVER COLO. 80204

OFFICE OF SUPERINTENDENT

TO: M & R Division and Coining Division

DATE: September 18, 1967

FROM: Cost Accounting

SUBJECT: 60% Copper, 40% Zinc Ingots - Foreign Experimental

Dept.
1700

Job Charge Numbers
1700 Supervision
1701 Indirect Labor
1702 Direct Labor

January 8 - estimated 1073 migrants needed for the year

Philippines Centaurs

25 Centaurs	12,000,000 / pro.	356 migrants
100 " "	40,000,000 " "	712 " "
Estimated total No of migrants required		1068
Total cost of Centaurs SF = 98 migrants		- 98
		970
Amount already migrants into yard		12
Amount of 95 migrants needed		880

Total 95 migrants cost to date	797
migrants into the yard	90
	887

Philippines

62% recovery -

1/12/72

PHIL

US

<u>AMT</u>	<u>DEN</u>	<u>DIAM</u>	<u>DIAM</u>	<u>DEN</u>
90, ^{stamped} mint	5	^{stamped} .724	^{blank} .730	14
140, "	10	.705	.695	54
90, "	25	.830	.827	104
30, "	50	1.002	1.080	254
150, "	1	1.319	1.094	504
			1.315	

5 Centavos 60% Copper 40% Zinc

German Silver 70% Copper 18% Zinc 12% Nickel

10 Centavos 2 625 Ingots

.25 " 2 763 "

.50 " 2 472 "

1 Peso

(.0641 thickness) (184.8 Gram Weight)

223.76

Philippines 30,000,000 pesos

Memorandum

TO : Superintendent's of Melting, Coining, Assay,
Cash & Deposits and Mechanical Division

DATE: February 17, 1972

FROM : Cost Accounting Branch

SUBJECT: Job Numbers for 5 Centavo, 10 Centavo, 25 Centavo, 50 Centavo and 1 Peso
Philippine Coins

Melting

<u>Dept.</u>	<u>Charge</u>	<u>Denomination</u>
7700	7756	Universal Ingot (10, 25, 50 Centavo & 1 Peso)

Process-Weighing

8100	8156	1 Peso
	8179	5 Centavo
	8180	10 Centavo
	8181	25 Centavo
	8182	50 Centavo

Rolling (Includes Slab Annealing)

7900	7956	1 Peso
	7980	10 Centavo
	7981	25 Centavo
	7982	50 Centavo

Material Handling

7800	7856-3	1 Peso - Strip
	7879-3	5 Centavo - Strip
	7880-3	10 Centavo - Strip
	7881-3	25 Centavo - Strip
	7882-3	50 Centavo - Strip
	7856-4	1 Peso - Scrap
	7879-4	5 Centavo - Scrap
	7880-4	10 Centavo - Scrap
	7881-4	25 Centavo - Scrap
	7882-4	50 Centavo - Scrap
	7856	Universal Ingot

February 17, 1972

Memorandum - (Continued)

Job Numbers for 5 Centavo, 10 Centavo, 25 Centavo, 50 Centavo and 1 Peso
Philippine Coins

✓ Blanking

<u>Dept.</u>	<u>Charge</u>	<u>Denomination</u>
8200	8256	1 Peso
	8279	5 Centavo
	8280	10 Centavo
	8281	25 Centavo
	8282	50 Centavo

Annealing

8300	8356	1 Peso
	8379	5 Centavo
	8380	10 Centavo
	8381	25 Centavo
	8382	50 Centavo

Upsetting

8500	8556	1 Peso
	8579	5 Centavo
	8580	10 Centavo
	8581	25 Centavo
	8582	50 Centavo

Selecting

8800	8856-2	1 Peso - Blanks
	8879-2	5 Centavo - Blanks
	8880-2	10 Centavo-Blanks
	8881-2	25 Centavo - Blanks
	8882-2	50 Centavo - Blanks
	8856-3	1 Peso - Coins
	8879-3	5 Centavo - Coins
	8880-3	10 Centavo - Coins
	8881-3	25 Centavo - Coins
	8882-3	50 Centavo - Coins

Stamping

8600	8656	1 Peso
	8679	5 Centavo
	8680	10 Centavo
	8681	25 Centavo
	8682	50 Centavo

UNITED STATES GOVERNMENT

Memorandum

TO : Superintendent's of Melting, Coining, Cash & Deposits, Assay, and Mechanical Divisions

DATE: August 2, 1971

FROM : Cost Accounting Branch

SUBJECT: Job Numbers for Philippine 1 Peso Order

Coining Division

Melting

	<u>Dept.</u>	<u>Charge</u>	<u>Denomination</u>
	7700	7756	1 Peso Ingot

Process-Weigh

	8100	8156	1 Peso
--	------	------	--------

Rolling (Including Slab Annealing)

	7900	7956	1 Peso
--	------	------	--------

Blanking

	8200	8256	1 Peso
--	------	------	--------

Annealing

	8300	8356	1 Peso
--	------	------	--------

Upsetting

	8500	8556	1 Peso
--	------	------	--------

Selecting

	8800	8856 B	1 Peso Blanks
		8856 C	1 Peso Coins

Stamping

	8600	8656	1 Peso
--	------	------	--------

Counting

	8700	8756	1 Peso
--	------	------	--------

Cash & Deposits Labor & Stores Items

Labor	1300	1356	Shipping, etc.
Stores	1300	1356	Boxes
Labor	1300	1357	Boxing Bags and
			Banding Boxes
Labor	1300	1358	Skids

Assay

	3500	7756	Ingot
--	------	------	-------



Buy U.S. Savings Bonds Regularly on the Payroll Savings Plan

Philippines -

Ten Centavo - 40,000,000 pes.

upset size - Same as dime - cent groove -

cut blank size - Same as dime - .695

Ingots - 716 ingots - 70 cu. 18 zn. 10 ni.

German Silver

3,591 oz Per Coil

30.87 Grain + ni - 2 grain

Twenty-five Centavos - 10,000,000 pes.

upset size - .811 - wore nickel groove

cut blank size - .825 - may get by

with new nickel punch (rolling on the light side)

Ingots - 358 ingots - 70 cu. 18 zn. 10 ni.

German Silver -

Rolling will follow this up after
El Salvador -

3,380 oz Per Coil

61.73 Grain + ni - 3 grain

UNITED STATES GOVERNMENT

Memorandum

DATE: February 8, 1971

TO : Superintendents of Melting, Coining, Assay,
Cash and Deposits and Mechanical Division

FROM : Cost Accounting Branch

SUBJECT: Job Numbers for Philippine Coins, 50 Centavo, 25 Centavo, 10 Centavo from
Manufactured "In-House" Strip and 5 Centavo from Purchased Strip

<u>Melting:</u>	<u>Dept.</u>	<u>Charge</u>	<u>Denomination</u>
Universal Ingot	7700	7779	Ingot
<u>Process Weighing:</u>	8100	8179	5 Centavo
		8180	10 Centavo
		8181	25 Centavo
		8182	50 Centavo
✓ <u>Rolling:</u> (Includes Slab Annealing)	7900	7980	10 Centavo
		7981	25 Centavo
		7982	50 Centavo
✓ <u>Blanking:</u>	8200	8279	5 Centavo
		8280	10 Centavo
		8281	25 Centavo
		8282	50 Centavo
<u>Annealing:</u>	8300	8379	5 Centavo
		8380	10 Centavo
		8381	25 Centavo
		8382	50 Centavo
<u>Upsetting:</u>	8500	8579	5 Centavo
		8580	10 Centavo
		8581	25 Centavo
		8582	50 Centavo
<u>Selecting:</u>	8800	8879	5 Centavo
		8880	10 Centavo
		8881	25 Centavo
		8882	50 Centavo
<u>Stamping:</u>	8600	8679	5 Centavo
		8680	10 Centavo
		8681	25 Centavo
		8682	50 Centavo



UNITED STATES GOVERNMENT

Memorandum

TO : M&R Coining, Mechanical & Assay Divisions

DATE: November 9, 1967

FROM : Cost Accounting

SUBJECT: Job Numbers for Philippine 5 & 10 Centavos, Make-Up & Melting thru Blanking Operations - For San Francisco Assay Office

<u>M&R Ingots</u>	Dept.	Job Charge	
	7700	7765	Five Centavo
	7700	7766	Ten Centavo

Coining Division

Rolling Includes - Rolling, Slab Annealing, and Slittering.

	Dept.	Job Charge	
Rolling	8200	8267 R <i>Rolling</i>	Five Centavo
Blanking	8200	8267 B	" "
Rolling	8200	8268 R <i>Slittering</i>	Ten Centavo
Blanking	8200	8268 B	" "

*Process Weigh
+
Materials Hand*

Preparation For	8200	8269	Five Centavo
Shipping Costs	8200	8270	Ten Centavo

Mechanical Division

	Dept	Job Charge	Job Request
Electricians & Machinists General Maintenance	6000	7704	#7771
Die Sets Charges	6000	8204	#8267 Five Centavo
	6000	8204	#8268 Ten Centavo
Electricians & Machinists General Maintenance	6000	8204	#8269

<u>Assay Division</u>	Dept.	Job Charge	
	3500	7765	Five Centavo
	3500	7766	Ten Centavo



PHILIPPINE 25 CENTAVO BLANKS

INGOT WEIGHT	400 lbs
TOTAL OZ. RECOVERED IN CUT BLANKS	2,900,544 oz
TOTAL INGOTS USED	891
OZ. RECOVERED CUT BLANKS PER INGOT	3,255 oz
PERCENT RECOVERED IN CUT BLANKS	.552
CUT BLANK THICKNESS	.053 $\bar{+}$.002
WEIGHT OF A CUT BLANK	61.73 $\bar{+}$ 3 (Grams)
DIAMETER OF A CUT BLANK	.827 $\bar{+}$.003
DATE STARTED	7-8-70
DATE COMPLETED	7-23-70
MATERIAL	GERMAN SILVER
TOTAL WEIGHT SHIPPED	2,893,544 oz
SHIPPED TO	SAN FRANCISCO
BALANCE IN OZ., IN CUT BLANKS	7,000 oz
HOW SHIPPED	CUT BLANKS IN TANKS
STANDARD NICKEL PUNCH DIE USED	

Philippine Blanks Via S.F.

Blank - 125 Ingt

5 Centavos #4 Punch

5,000,000 pieces

0.043 strip gauge

⁶⁰40% Copper, ⁴⁰60% Zinc

2.5 grams $\pm$ 3 grams (Blank coin)

38.58089 grams

0.083765 tr. oz.

18.4 MM diameter

0.7244" " (coin ?)

0.730 Dia. blank

181 pcs/lb

S. S. Shipping two 6" blanking dies

silver reg. 1¢ to 5 centavo

German Silver - 95 Ingt

10 Centavos #3 Punch

5,000,000 pieces

0.035 strip gauge

70% Copper, 18% Zinc, 12% Nickel

2.0 grams $\pm$ 2 grams (Blank coin)

30.864712 grams

0.06430148 tr. oz.

17.9 MM diameter

0.7047" " (coin ?)

0.695 Dia. blank

226.8 pcs/lb.

Use reg. 10¢ blanking dies

Keep all slabs and coils marked & separate.

(The Centavo standard weights are in green cupboards)

M & R

Coiner

11-12-67

BRASS

5-CENTAVOS

BRASS

Rec. @ .200

PASS -	DIAL	GAUGE	X-Ray	COILER
1-	210	.180	-	2
2-	180	.150	-	3
3-	160	.130	-	4

Wanted like.
 to try anneal
 at .150 then
 finish.

ANNEAL

4-	130	.087	-	3
5-	110	.073	-	4
6-	92	.057	88	3 1/2
7-	78	.043	69 + 1/2	4

82-83

Dia .730

Philippine 5 Centime

Brass $\frac{60\%}{Cu} + \frac{40\%}{Zn}$

Pass Dial Thickness

Rec'd 1.725

1	60	1.560
2	180	1.440
3	65	1.330
4	205	1.230
5	95	1.125
6	240	1.025
7	150	.960
8	60	.850

Anneal

9	190	.715
10	100	.635
11	25	.550 "15 ft long"

Anneal

12	200	.460
13	100	.360
14	30	.310
15	220	.250
16	170	.200

Finish Std. Blank .038

PHILIPPINE

German Silver - 10 CENTAVO -

Slabs received from Roughing Mill at .205

Pass	Dial	Image	X Ray	Turns on roller	Amms
1	215	.180		down 1 turn	800
2	180	.145		" 3	750
Anneal					
3	150	.105		2	800
4	125	.080		4 $\frac{1}{2}$	650
5	100	.060		5	500
6	89	.045	.072	5 $\frac{1}{2}$	500
7	95	.037 ⁹	.060 058	5	300

make Fin strip edge .036⁵ to .037⁵
345 355

blanks O.K. .036 to .039

Diameter of blank .695

25 CENTAVO

PHILIPPINES

NEW

RECEIVE AT .205

PASS

DIAL

GUAGE

XRAY

1

240

.190

2

215

.170

3

190

.143

ANNEAL

4

150

.105

5

125

.080

6

110

.065

103

7

96

.053

.082⁺¹

EDGE .050 - .051

REVISED 10-SENTINES- PHILIPPINE

3-24-71

REC. @ 220

GERMAN. AG.

PASS	DIAL.	GAUGE	X-RAY
1	220	.185	
2	195	.165	
3	175	.145	

ANNEAL

4	150	.105	
5	125	.080	
6	105	.065 -	USE - PLATE
7	95	.050	" "
8	90	.040 -	SELECT 064
9	90	.0379	058 1/4"

EDGE. 035

DIA. 695

WT-30.87

10-SENTINES-PHILIPPINE-

10-12-70

REC. Q 205

GERMAN AG.

PASS	DIAL	GAUGE	X-RAY
1	240	.190	
2	215	.170	
3	190	.145	

ANNEAL

4	150	.105	
5	125	.080	
6	100	.057	USE PLATE LAST 3 PASSES
7	90	.045	SELECT - 067
8	93	.0379	058-

EDGE-.035 CENTER-.0385 DIA:.695 WT-30.8795. ± 2

25-CENTAVO old

PHILIPPINE - 7994
Receive at .205

PASS - DIAL. GAUGE X-RAY

1 - 215 .180

2 - 180 .145

ANNEAL

3 - 150 - .105

4 - 125 - .080

5 - 110 - .065 - .103

6 - 96 - .053 - .083 + $\frac{1}{2}$

edge = .050 - .051

NEW.

25- SENTINEL- PHILIPPINE

10-26-70

REC @ 220

GERMAN-A.G.

PASS

DIAL

GAUGE

X-RAY

1 230 .185 - .190

2 195 .165

3 175 .145

ANNEAL.

4 150 .105

5 125 .080

6 110 .065 SELECT 103

7 96 .053 082+

EDGE-052 CENTER-054 DIA.-.827 WT-61.73gms ± 3

1- PESO - PHILIPPINE

3-15-71

Rec @ 220.

GERMAN A.G.

PASS	DIAL	GAUGE	X-RAY
1	220	.185-190	
2	195	.165	
3	175	.145	

ANNEAL.

4	155	.110	
5	140	.090	
6	135	.080	select 125 straight up
7	135	.0736	must 115- ⁺ / ₈

EDGE - 072

CENTER .074

Dia. 1.328

wt. 2.23.76 grs

Philippine 10 d

San Francisco

9/15/69

Gauge 0.35
Dia .695

Annulity 1400 5 RPM.

Stamp dia .705 $\pm$ ~~9~~

WT 30.87 grams $\pm$ 3

25

Gauge 0.54

Dia .825

Annul 1450 5 RPM.

Stamp Dia .827 $\pm$ 0.03 ~~from~~

WT 61.73 grams $\pm$ 3

50 - SENTIMO - PHILIPPINE -

4-30-71

Rec @ 200

GERMAN A.C.

PASS

DIAL.

GAUGE

X-RAY

1

220

.185-.190

2

195

.165

3

175

.145

ANNEAL

4

155

.110

5

130

.085

6

110

.072 - SELECT - III

7

105

.0625

09.7^{+3/4}

EDGE: .0605 CENTER: .063

DIAM: - 1.080 - 1.084

WT - 123.46

1-PESO-Philippine

3-15-71

Rec. @ 220

Getman A.G.

Pass	Dial	Gauge	X-Ray
------	------	-------	-------

1	220	.185-190	
---	-----	----------	--

2	195	.165	
---	-----	------	--

3	175	.145	
---	-----	------	--

Anneal

4	155	.110	
---	-----	------	--

5	140	.090	
---	-----	------	--

6	135	.080	125
---	----------------	------	-----

7	135	.0736	115
---	-----	-------	-----

113

Edge .072 Center .074 Dia. 1.328 Wt. 223.76 GR.

Notes on Philippine Currency

